

Appl.No. 10/710,716

Amdt. Dated April 18, 2006

Reply to Office action of January 18, 2006

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. Canceled
2. Canceled
3. Canceled
4. Canceled
5. Canceled
6. Canceled

7. (New) A method of manufacturing a diaphragm backing plate for use in a brake booster comprising the steps of:

moving a coil of metal to a first station, said coil having a first and second sides to define a first width;

applying a force to remove a section from the roll of metal to create a first plate defined by a peripheral surface having equal and parallel sides connected to each other by an arcuate segment each of which has a radius that is approximately equal to one-half of the width of the coil plus a minimum width of a desired peripheral lip for the diaphragm backing plate and wherein each parallel side is located at an equal distance from the center of the first plate along a X coordinate in a Y coordinate that is defined by a point where the radius intersects the Y coordinate;

punching a pilot hole in the center of the first plate;

moving the first plate to a second station where the parallel sides and pilot hole retain the alignment therein; and

thereafter rolling the peripheral surface on said first plate to define a uniform diameter for a resulting second plate with the desired peripheral lip, said

uniform diameter for the second plate⁶ being approximately equal to the width of said coil less twice minimum width for said lip while said lip has a scalloped surface.

8. (New) The method as recited in claim 7 further including the step of:
punching a second pilot hole along the axial center of said coil at distance that is equal to said radius to define an axial center for a next plate.

9. (New) The method as recited in claim 8 wherein said step of removing a section of said coil includes the forming of complimentary sides for said first plate and next plates.